

Date: Thursday, 06/12/2007 10:36:52 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D135-751-011 REWORK
Job Number : 36166	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D135751011
This Issue : 06/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : ECN1036
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 36164	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 24/12/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 1 Um: Each
Comment :	



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:
1 X D135-751-011 B28955

2.0	D135751011	SKIDTUBE INSTALLATION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SKIDTUBE INSTALLATION

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

REMOVE 1 X D3508-7 REV.B WEARPLATE
REMOVE 2 X D3512-1 REV.B WEARPLATE
SCRAP BOTH
REWORK SKID PER DRWG IAW D3507 REV.C
(DRILLING DETAIL HAS CHANGED)

DP
7-12-6

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ALuminum ROD m 105138

WELD 2 X D3504-5 CROSSBOLT SPACERS
PER DRWG D3507 REV.C

BE 07-12-13

6.0

D35045

CROSSBOLT SPACER



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
CROSSBOLT SPACER

B 36181

BE 07-12-13

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QC6

12/14 (X)

QC9 07/12/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 105914

(X)

REMOVE ALL EXISTING PARTS:
WEARPLATES, CAPS, INSERTS, BOLTS, WASHERS
KEEP EXISTING WEARPLATES & CAPS
DISCARD INSERTS, BOLTS & WASHERS

M 07-12-12 (X)

M 07/12/17

N/A
07-12-17

MASK D3506-1/-3 DOUBLER, PLUG HOLES
RE-POWDER COAT PER QSI005
(STRIP IF NECESSARY)

CONTINUE PULLING PARTS FROM ORIGINAL
W/O 28955 - KEEP THESE 2 W/O'S TOGETHER

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 07/12/17 (P)

10.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)
Insert

NOT
REQUIRED
07-12-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 36166

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Insert

NOT
REQUIRED

07-12-17

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
RE-ASSEMBLE CAPS (SIKAFLEX)
& WEARPLATES
PER DRWG D3507 REV.C

M105585
08-01

PICK NEW 1 X D3508-7 REV.C B

B31198

1x D3558-7

INSTALL PER DRWG D3507 REV.C

B: D30001

FL 01/12/17 ①

PICK 4 X D3492-043 PLUGS B

D35840

INSTALL PER DRWG D3507 REV.C

WING WALK > BR 07-12-17

13.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PLUG ASSEMBLY

D35840

FL

14.0

D35087

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARPLATE

B31198 D36179

FL

15.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)
BOLT

M106431

FL

16.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)
washer

#33

M106302

FL 07/12/17 ①

ADD CAP D2965-3 B 24293

①

ADD AFT CAP D2965 B 36392

BR 07-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36166

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt

m106552.

FL

18.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Screw

m15072

FL

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 4/12/18 (26)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PICK KIT FROM ORIGINAL W/O 28955

ADD:

2 X D3512-1 **REV.C** WEARPLATE B

no quant
(B36180)

5 8/12/19 (X1)

21.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
WEARPLATE

B36180

5 8/12/19 (X1)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 7/12/19

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP
USING NEW B/N - CHG 001

PNAT *6/7/21 (1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/12/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36166

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D57112129
1207-12-24

Job Completion



POSITIVE RECALL

EFFECTIVE 07-12-17 AUTH U

RELEASED 07-12-19 DATE U

36166

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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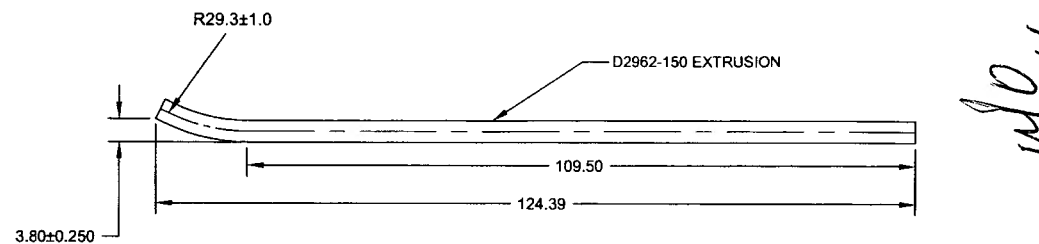
NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AEL-1032-130	INSERT
1	AEL-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

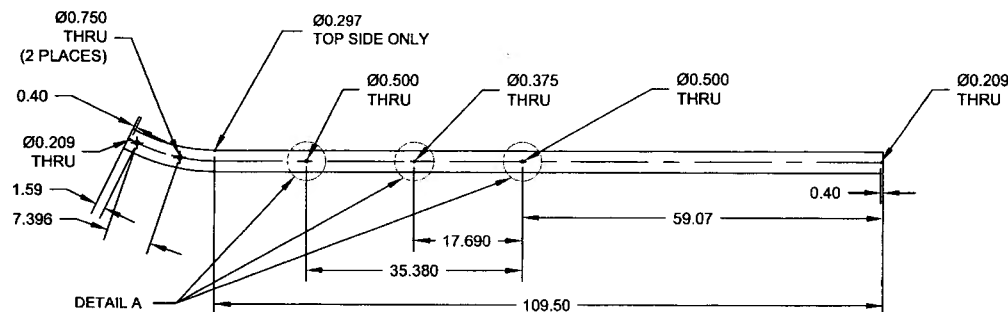
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEL-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

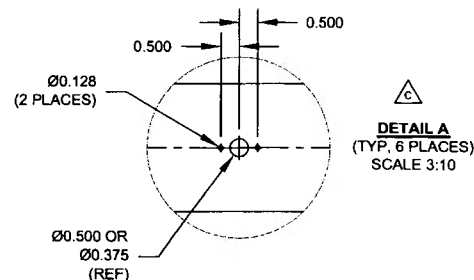
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JC		
CHECKED	BE		
MFG. APPR.	BE		
APPROVED	JP		
DE APPR.	JP		
DATE	07.09.19		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 REV. C SHEET 1 OF 2 TITLE EC 135 SKIDTUBE SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



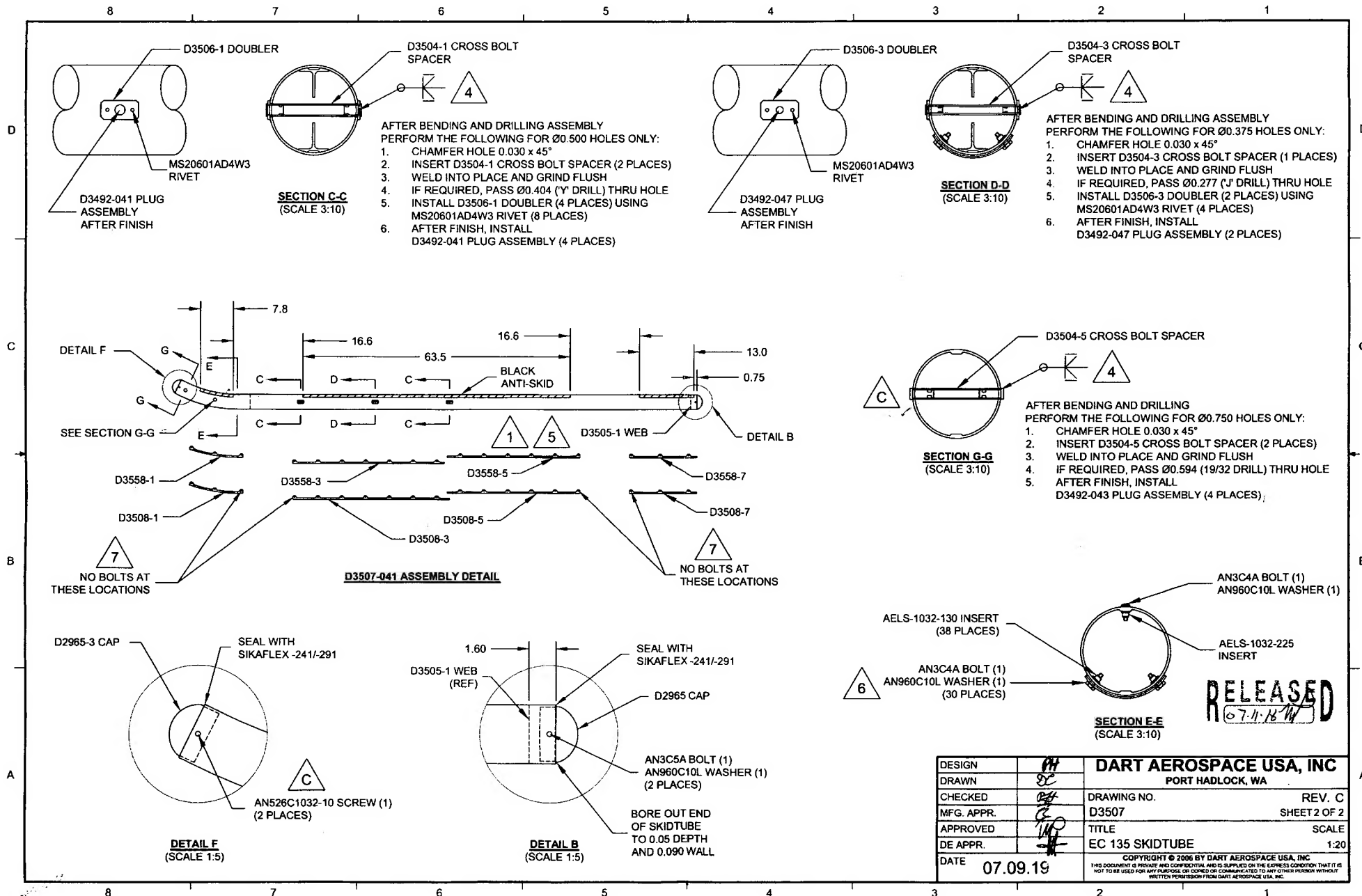
D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10



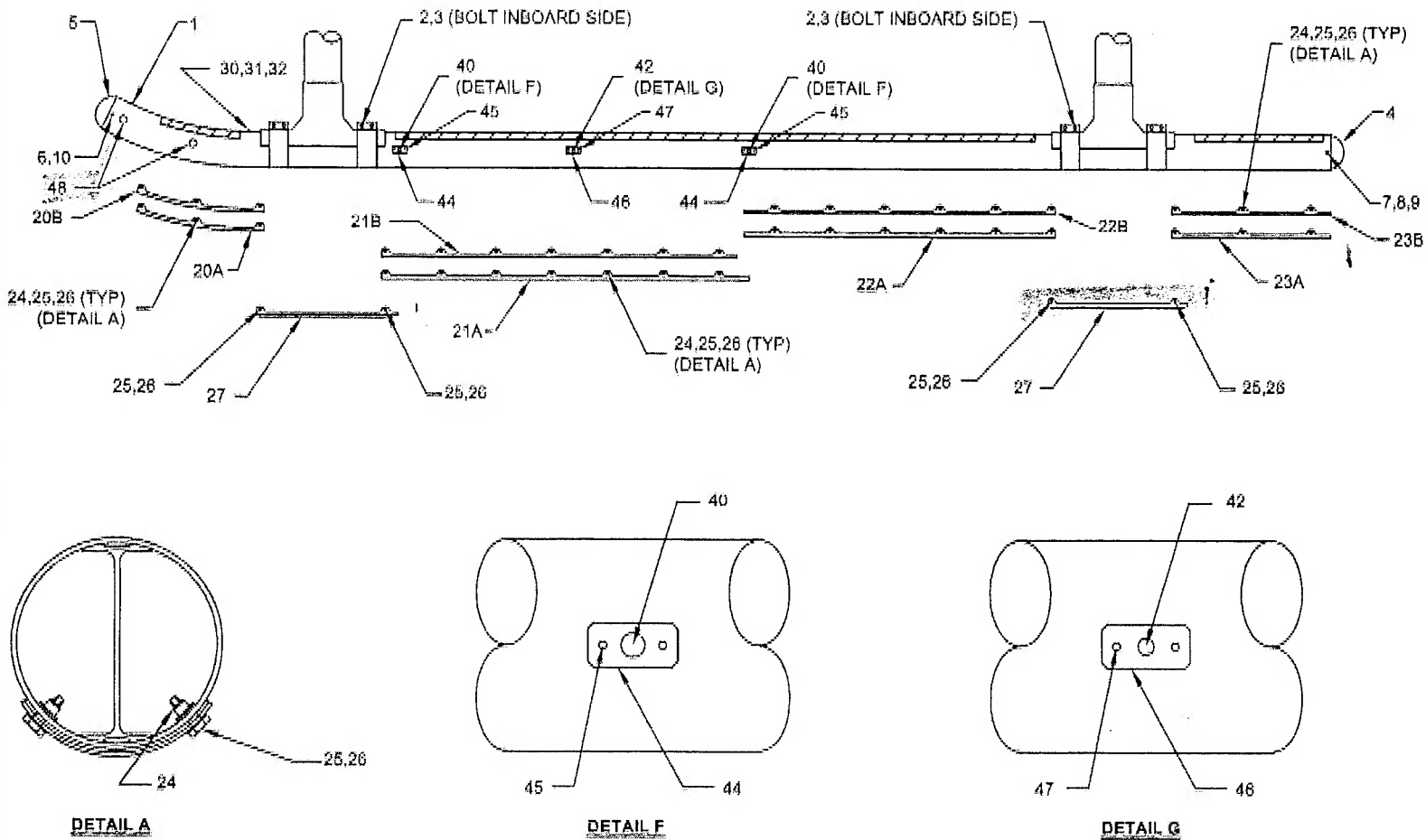


FIGURE 2 - D135-751-011 SKIDTUBE INSTALLATION

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Revision: C

Date: 07.09.20